

Work Order ID 124016

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124016

Page 1

Item ID: D350-636-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.
 Start Date: 9/05/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/05/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 1409-05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2750-041	G								

100 Document Control 0.00 **54** **OCT 15 2014** **DAS 38 9-89**

100

DC

Doc.Control -USB or Paperwork

Memo

record fwd angle: 89.3° Doc 0.00

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

ML1

OCT 15 2014

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Item ID: D350-636-011

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.								
	ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE								
	Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B)								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	7- Open up holes of Detail A to 0.297" (total of 2 holes per side)								
	8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004								

DGC
14-9-10

BEND-09-11

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 Start Date: 9/05/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/05/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	A/R Aluminum Rod batch: <u>M129399</u>								
	9-Grind welds flush as per Dwg D2750								
120	QC10- Inspect visual per QSI004- ground welds	0.00							DAS 9 9-89
120									
QC	Memo	0.00							① 14-09-19
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS 03 8-89  14-9-18

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Item ID: D350-636-011

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop ***NS2***Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

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03
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14-9-19

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Item ID: D350-636-011

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop ***NS2***

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes using hole saw of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole using un-bit to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 129457 exp. date: 11-11-20								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: M129399								
	9- At section AJ-AJ drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								

Handwritten signature 14-9-19

Handwritten signature 14-9-19

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Item ID: D350-636-011

Accept

N19000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D275012-Deburr holes, ensure tube is free of all scratches before sending to
paint.

170

QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo 0.00

Quality Control

① 140924 DAS
9
9-89

180

QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo 0.00

Quality Control

VERIFY C'BOARD IS GOOD

① 11-09-24 DAS
9
9-89

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N900040100

Setup Start ***NS1***

Revision ID:

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Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1		7/6 149-25	
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							
200									
SprayPaint	Memo	0.00				1			DAS 41 9-89
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>129568</u>								14-9-30
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>129977</u>								
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								x1 h11 d Hl 146007 DAS 15 9-89

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Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D2750								
	2-Inspect for Foreign Objects								
	3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M129457</u> EXP DATE: <u>4/11</u>								
	4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M129305</u> RTU 598 Bhl M125797 exp 6/06								
	5- Coat all exposed fasteners with "LPS Procyon" batch: <u>M122906</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240									
QC	Memo	0.00							
Quality Control									

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Item ID: D350-636-011

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop ***NS2***Start Date: 9/05/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/05/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									



Picklist Print

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Work Order ID: 124016

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC IPP REV:R 13.08.27 PER ECN13-594 DD
 VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3492-1		Manufactured	No			230	Each	121.0000	8	8			
D3492-1									**			10/10/07	
Plug													

Location	Loc Qty	Loc Code
FP001	121	
111578	2	
114879	7	
119646	2	
120519	50	
122460	60	

D3492-3		Manufactured	No			230	Each	142.0000	8	8			
D3492-3									**			10/10/07	
Plug													

Location	Loc Qty	Loc Code
FP001	142	
104853	24	B124027
107331	1	
112739	1	
115807	6	
118977	10	
123464	100	

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Work Order ID: 124016

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

383.0000

8

8

NAS1611-010

O-RING

**

ul 10/02

Location

Loc Qty

Loc Code

FP001

383

m126988

3

m127813

4

m128375

10

m129198

44

m129405

82

m129523

240

✓ 6

NAS1149D0863J

Purchased

No

250

Each

795.0000

2 2

NAS1149D0863.J

Washer

DAS
38
9-89

**

00...

Location

Loc Qty

Loc Code

ST276

595

118078

2

125268

586

125484

7

ST2776

200

125635

200

D2744

Manufactured

No

110

Each

53.0000

1

1

D2744

Cap

**

FE14-09-11

Location

Loc Qty

Loc Code

LG001

53

113128

52

115440

1

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

1.0000

1

1

D2600-3-BENT

Extrusion Bent

DGC 14-9-10

Location

Loc Qty

Loc Code

LG002

123533
119680

1

1

①

D2743

Manufactured No

160

Each

192.0000

8

8

D2743

Crossbolt Spacer

BE 14-09-22

Location

Loc Qty

Loc Code

LG001

192

109799

1

112729

59

119609

58

120481

74

8

D2739

Manufactured No

160

Each

13.0000

1

1

D2739

350 I Beam

Location

Loc Qty

Loc Code

LG

10

123536

10

LG002

3

117245

2

117803

1

①

14-9-19 JK

D3490-3

Manufactured No

160

Each

72.0000

4

4

D3490-3

Cross Bolt Spacer

BE 14-09-22

Location

Loc Qty

Loc Code

LG

72

122458

22

122751

50

2

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

100.0000

4

4

D3490-1

Cross Bolt Spacer

BE14-09-22

Location

Loc Qty

Loc Code

LG

85

122457

85

LG001

15

112737

1

116358

14

Each

258.0000

38

ALS4-1032-225

AELS8-1032-225

Purchased

No

AI S4-1032-225

Rivnut

ALS7-1032-225

el 11/10/07

Location

Loc Qty

Loc Code

FG

30

M127028

30

M128649

X36

ST267

228

M127028

10

M127092

26

M128179

192

D3793-3

Manufactured No

230

Each

8.0000

1

1

D3793-3

Wearplate Aft

el 11/10/07

Location

Loc Qty

Loc Code

FP001

1

B123333

104212

1

FP002

7

120141

7

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased No

230

Each

73.0000

1

1

AN8C35A

Bolt

**

ll 10/10/07

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

69

m126293

29

m127823

1

m130114

39

x1

D3793-1

Manufactured No

230

Each

11.0000

1

1

D3793-1

Wearplate Fwd

**

ll 10/10/07

Location

Loc Qty

Loc Code

FP002

11

112741

2

120212

8

92382

1

x1

D3488-041

Manufactured No

230

Each

7.0000

1

1

D3488-041

Blade Fitting LH

**

ll 10/10/07

Location

Loc Qty

Loc Code

FP001

7

116834

6

88255

1

x1

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Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230

Each

11.0000

1

1

D3794-3

Gasket Aft

**

ll 11/10/07

Location

Loc Qty

Loc Code

FP001

11

111457

8

122529

2

92658

1

X1

AN6C44A

Purchased No

230

Each

45.0000

4

4

AN6C44A

Bolt

**

ll 11/10/07

Location

Loc Qty

Loc Code

FG

2

103964

2

ST333

43

m128319

2

m128700

1

m129199

40

✓4

MS21083C8

Purchased No

230

Each

64.0000

1

1

MS21083C8

Nut

**

ll 11/10/07

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

✓1

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D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

15.0000

1

1

D3536-25

Gasket Center

all 10/03

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

9

110652

1

123300

7

93696

1

B124049

xl

D3631-1

Manufactured No

230

Each

126.0000

8

8

D3631-1

Washer

all 10/07

Location

Loc Qty

Loc Code

FP001

126

110258

16

119553

10

123452

100

xl

D3791-1

Manufactured No

230

Each

6.0000

1

1

D3791-1

Wearpad

all 10/07

Location

Loc Qty

Loc Code

FP001

1

92689

1

FP002

5

118942

5

B120343

xl

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Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

3,653.000

38

38

NAS1149C0332R

WASHER

all 11/10/07

Location

Loc Qty

Loc Code

CA

83

m129682

83

ST278

3570

122063

41

125654

609

m126319

61

m127306

2500

m127410

75

m127831

26

m128591

75

m129499

183

x38

D2745

Manufactured

No

230

Each

145.0000

8

8

D2745

Bushing

all 11/10/07

Location

Loc Qty

Loc Code

ST010

145

107336

4

113176

2

117099

7

119572

51

122643

73

90323

2

93336

6

x2

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Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

1,058.000

4

4

AN3C6A

Bolt

**

all 1/10/07

Location

Loc Qty

Loc Code

FG

10

122416

10

ST513

1048

m125709

52

m128769

996

XJ

NAS1611-013

Purchased

No

230

Each

140.0000

8

8

NAS1611-013

O-RING

**

all 10/10/07

Location

Loc Qty

Loc Code

FP001

140

m128375

72

m129430

68

XJ

D3535-25

Manufactured

No

230

Each

24.0000

1

1

D3535-25

Wearplate Center

**

all 10/10/07

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

22

110744

1

123415

20

93278

1

XJ

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Page 11

Work Order ID: 124016

124016

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D3794-1 Manufactured No

230 Each 2.0000 1 1

D3794-1

Gasket Fwd

**

ll 11/10/07

Location

Loc Qty

Loc Code

FP001

2

109207

1

13123447

93381

1

✓

MS21043-6 Purchased No

230 Each 58.0000 4 4

MS21043-6

NUT

**

ll 11/10/07

Location

Loc Qty

Loc Code

FG

20

103693

20

11130325

ST306

38

m127255

6

m127813

32

✓

D3493-1 Manufactured No

250 Each 139.0000

D3493-1

Washer

**

2 2

OCT 15 2014

DAS

06

9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST046

129

109105

129

2

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

Picklist Print

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Page 12

Work Order ID: 124016

124016

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

64.0000

2 2

MS21083C8

Nut

DAS
38
9-89

**

1130358

DAS
06
9-89

Location

Loc Qty

Loc Code

ST302

64

m127255

5

m128119

3

m128798

56

AN8C21A

Purchased

No

250

Each

62.0000

2 2

AN8C21A

Bolt

DAS
38
9-89

**

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

2

123966

2

ST332

60

m127061

2

m127823

3

m129888

55

NAS1515H3L

Purchased

No

230

Each

293.0000

4 4

***NAS1515H3L ***

Washer

**

11/10/07

Location

Loc Qty

Loc Code

FG

40

102472

40

ST273

253

m127831

136

m128976

117

V4

Picklist Print

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Page 13

Work Order ID: 124016

124016

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 9/05/14

Required Date: 9/05/14

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

48.0000

1 1

D2741

Blade

DAS
38
9-89

**

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

10

100664

5

113640

2

115522

3

ST538

38

118387

38

D3532-1

Manufactured No

250

Each

34.0000

2 2

D3532-1

Spacer

DAS
38
9-89

**

Location

Loc Qty

Loc Code

ST048

34

115855

3

117198

3

122723

21

123513

7

OCT 15 2014

DAS
06
9-89

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, AL ODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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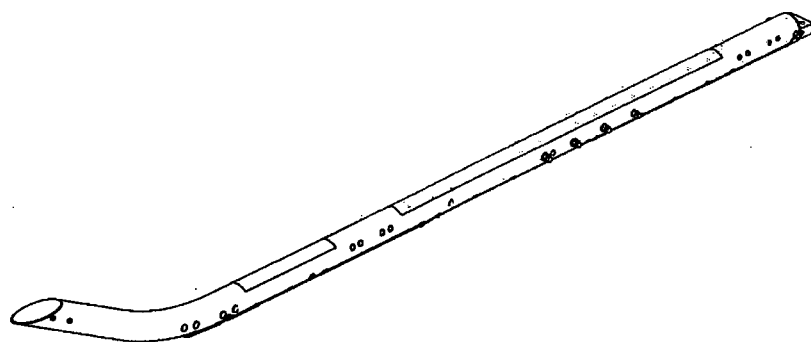
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G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS: INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
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MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

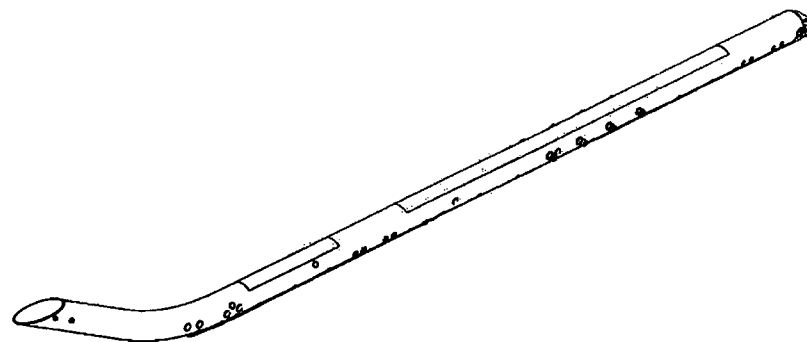
DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY
REV. G
SHEET 1 OF 11
SCALE
NTS

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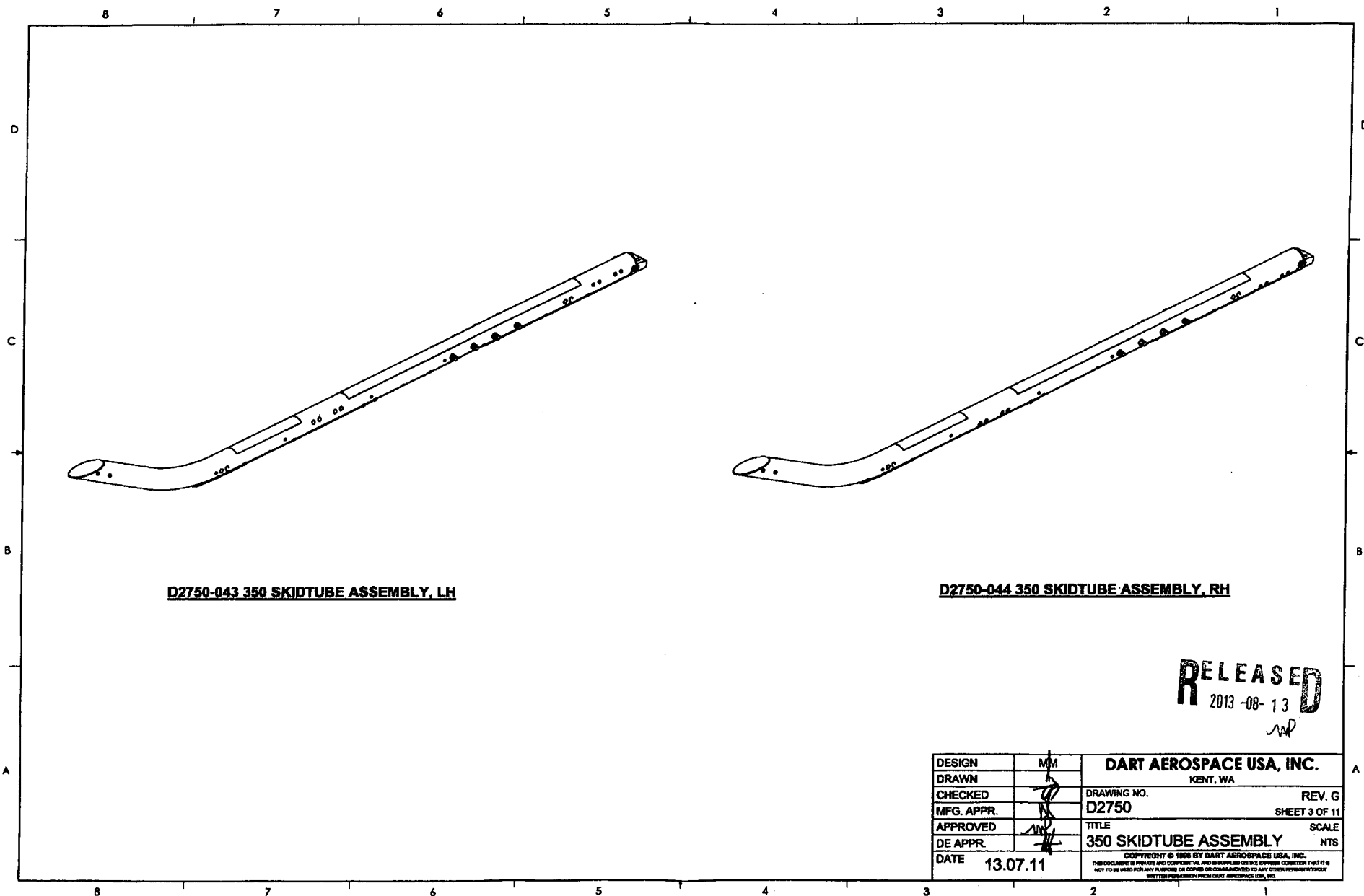
D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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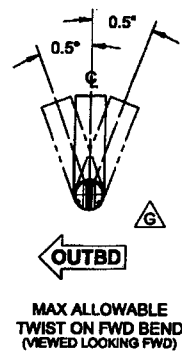
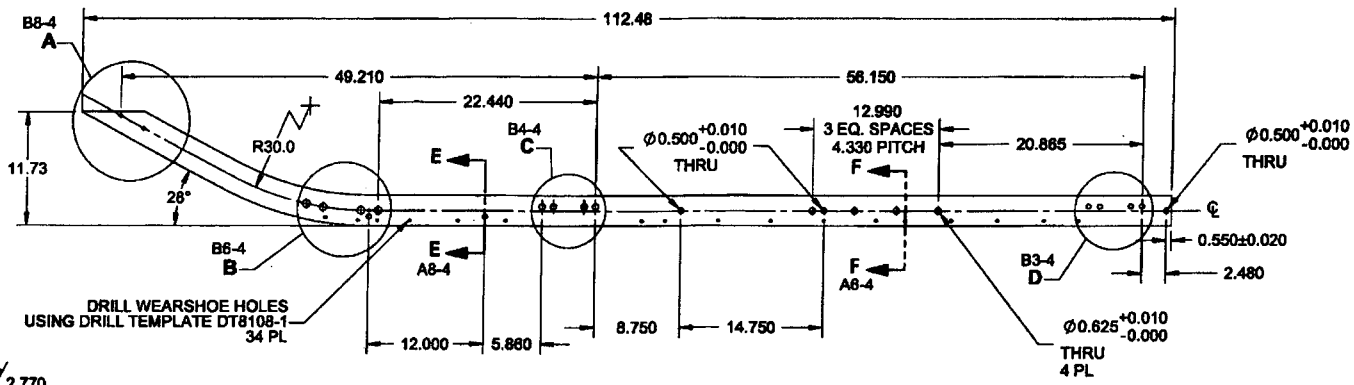
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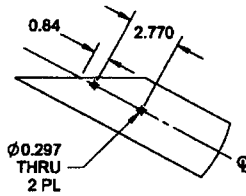
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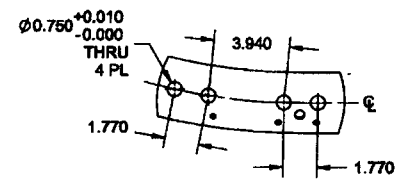
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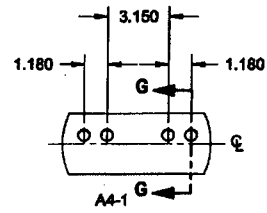
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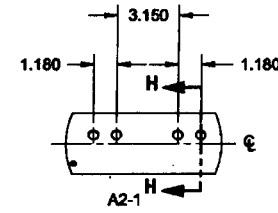
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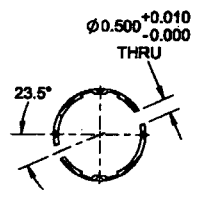
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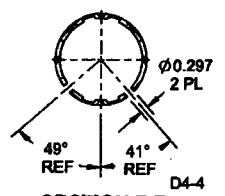
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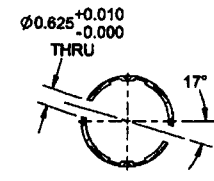
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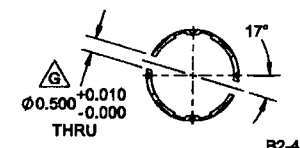
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



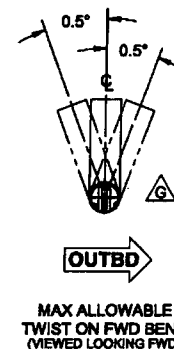
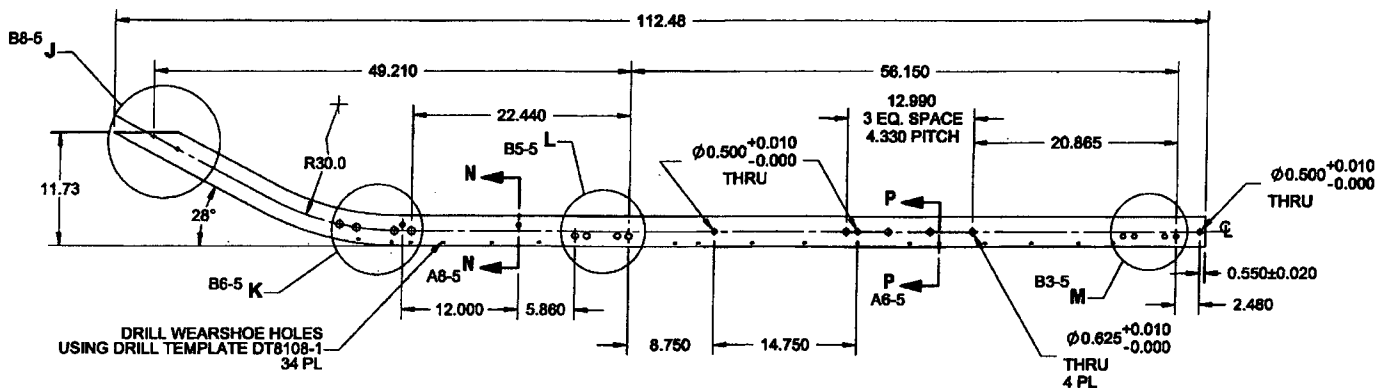
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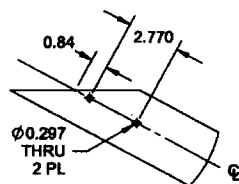
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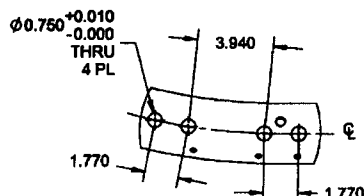
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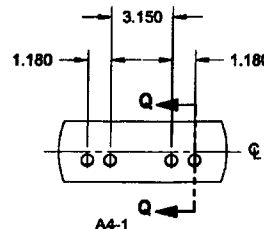
D2750-2 RH SKIDTUBE



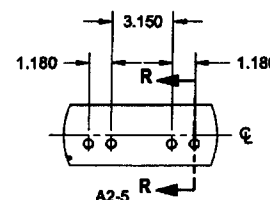
D8-5
DETAIL J
SCALE 2X



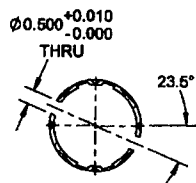
C7-5
DETAIL K
SCALE 2X



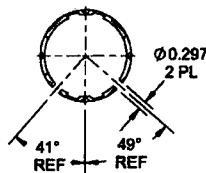
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SCALE 2X



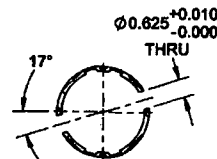
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SCALE 2X



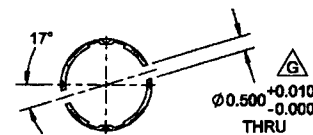
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C4-5
SECTION P-P
SCALE 3X, 17 PL



B5-5
SECTION Q-Q
SCALE 3X, 4 PL

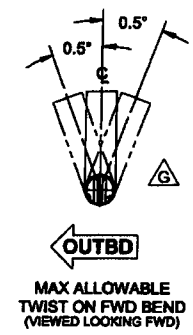
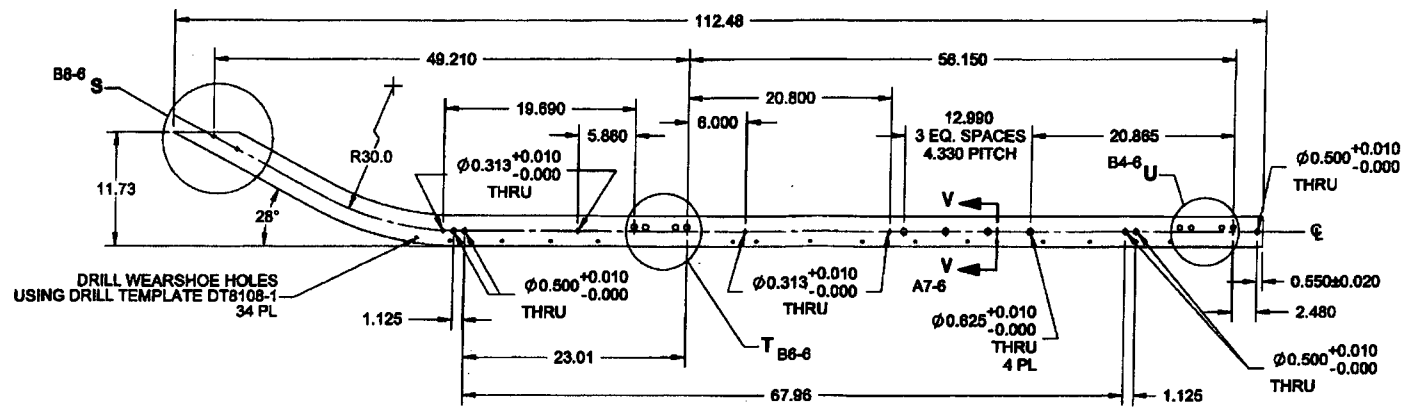


B3-5
SECTION R-R
SCALE 3X, 4 PL

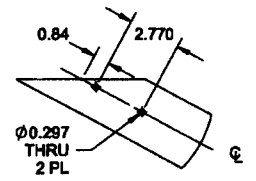
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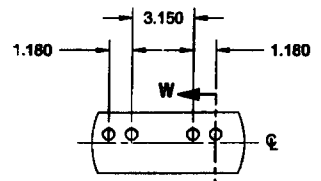
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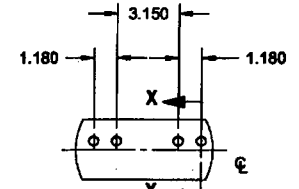
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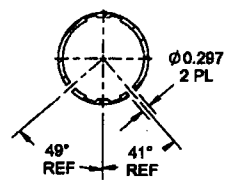
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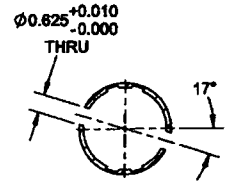
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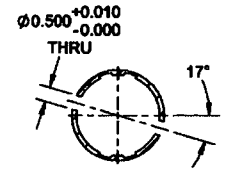
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

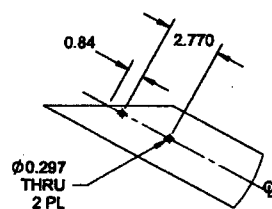
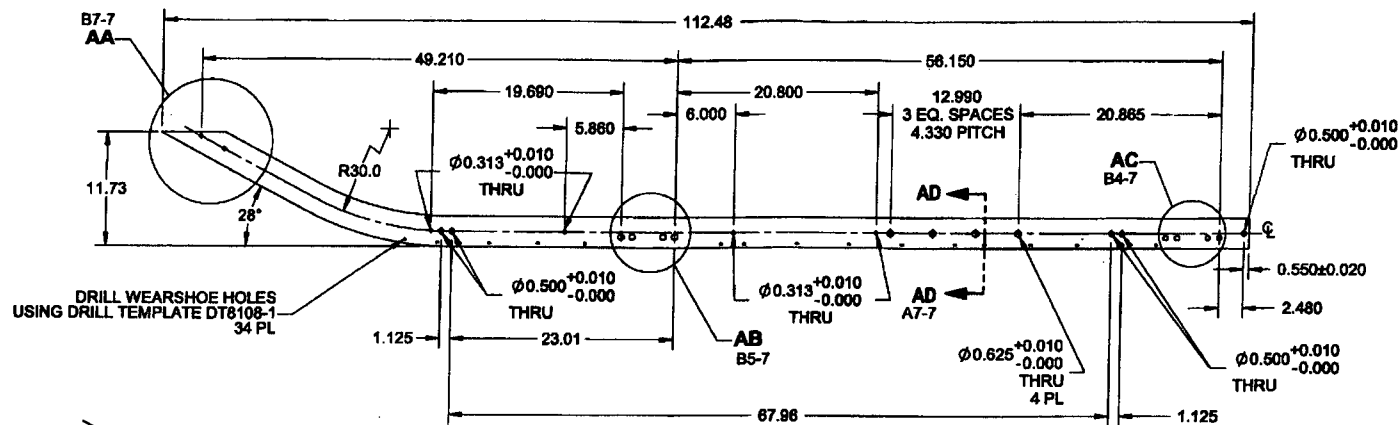


SECTION X-X
SCALE 3X, 4 PL

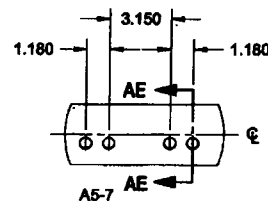
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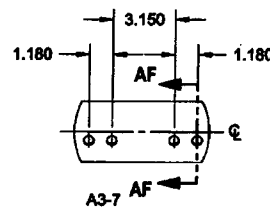
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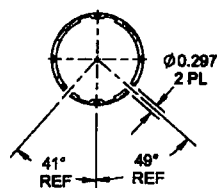
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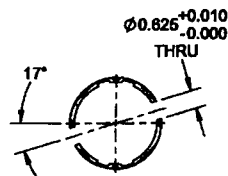
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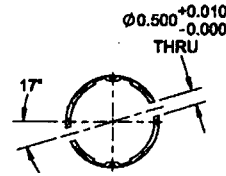
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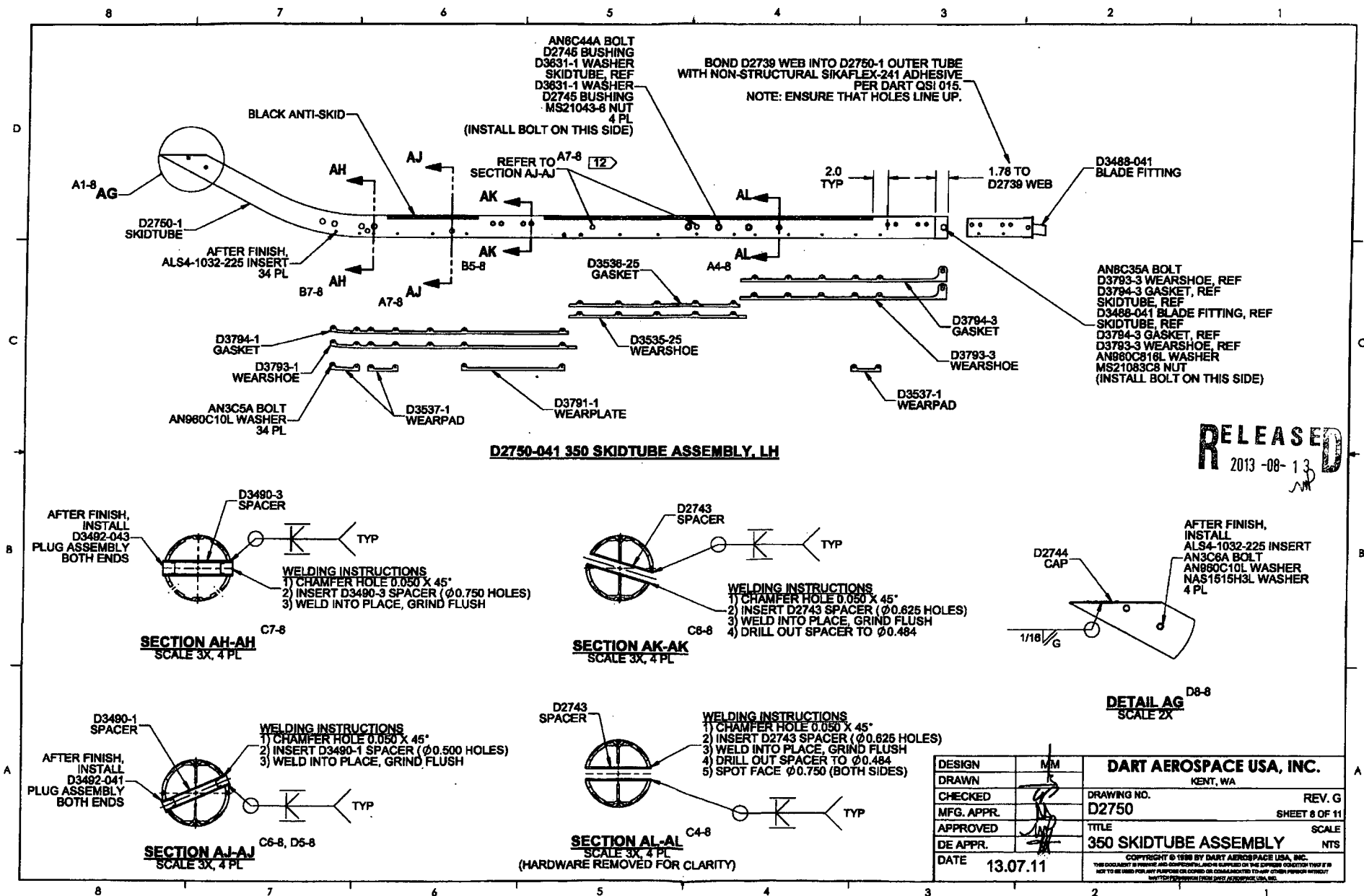
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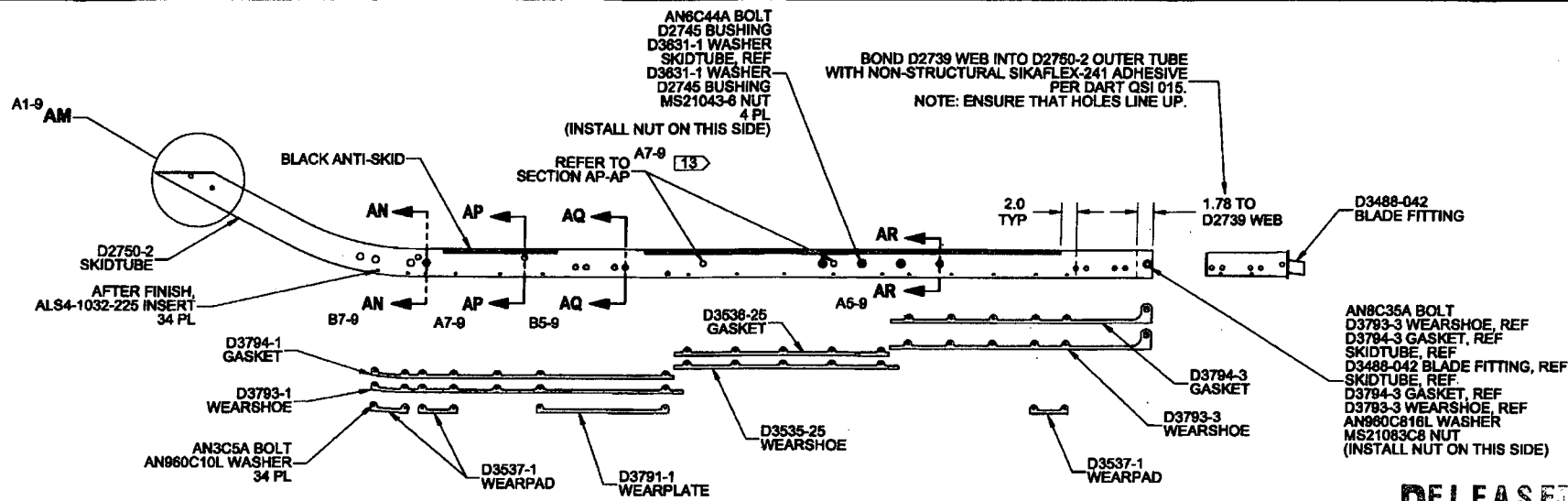
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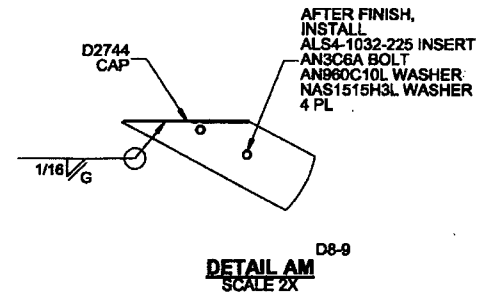
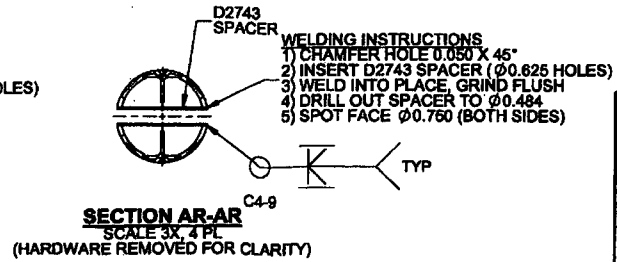
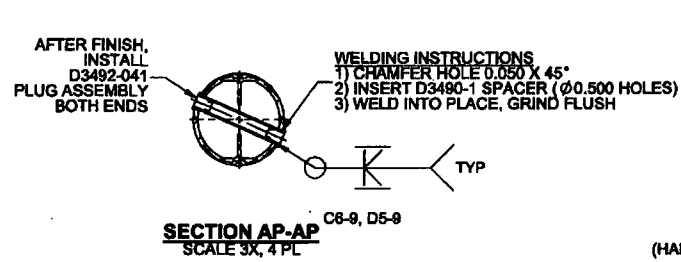
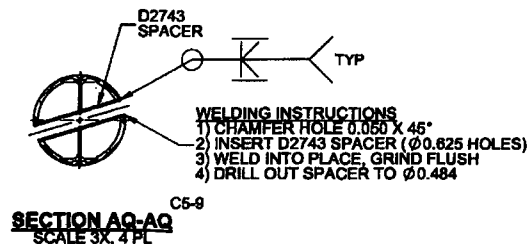
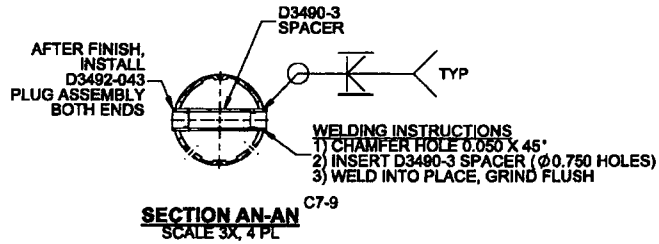
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